



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D119-646-241
Job Sheet 192325



Part No: D119-646-241

Job Qty: 1 ea

Part Name: AW119 Replacement Skidtube with Heavy Duty Wearplates - Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/21/19

Job Tracking No:

Due Date: 4/10/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG IIN-D119-646 REV D, D3887-045 REV E SHEETS 4, 6-11 IPP RevA: New issue DD verified by:EC IPP REVB 12.11.05 (DEOD3887-B-1)(ecn 12-675) DD verf:JLM IPP REV:C 13.03.20 per chg003 ECN13-534 DD verf:JLM IPP REV:D 17.05.19 as per dwg D3887 rev.e DD verf:JFS

Ship Via:

Bill of Materials



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S165231



Part: D119-646-241

Job No: 192325

Serial No/Batch: S165231

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SR02024SE 18/10/17, TC STC LcA P-09-0407-RDIMS-

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/10/19	0.00	0.00	Start Up Skid tubes-1		
110	Skid tubes	1 pcs		4/10/19	0.77	0.05	Skid tubes-1		
120	HandFinish	1 pcs		4/10/19	0.00	0.79	HandFinish1		
121	QC	1 pcs		4/10/19	0.00	0.00	QC7-1		
122	QC	1 pcs		4/10/19	0.00	0.00	QC5		
130	Skid tubes	1 pcs		4/10/19	0.00	2.38	Skid tubes-1		
135	QC	1 pcs		4/10/19	0.00	0.00	QC5		
140	Skid tubes	1 pcs		4/10/19	0.00	2.38	Skid tubes-1		
150	QC	1 pcs		4/10/19	0.00	0.00	QC5		
160	Skid tubes	1 pcs		4/10/19	0.00	2.44	Skid tubes-1		
170	QC	1 pcs		4/10/19	0.00	0.00	QC5		
180	QC	1 pcs		4/10/19	0.00	0.00	QC10		
190	HandFinish	1 pcs		4/10/19	0.00	0.33	HandFinish2		
200	Powdercoat	1 pcs		4/10/19	0.00	0.20	Powdercoat1		
210	QC	1 pcs		4/10/19	0.00	0.00	QC3		
240	HandFinish	1 pcs		4/10/19	0.00	0.79	HandFinish4		
250	QC	1 pcs		4/10/19	0.00	0.00	QC5		
258	DC	1 pcs		4/10/19	0.00	0.00	DC		
260	Packaging	1 pcs		4/10/19	0.00	0.00	Packaging3-1		
270	QC21-FG	1 Ea		4/10/19	0.00	0.00	QC21		

Part Op 110 - 1- inspect Mat'L D2500-1-190 for damage 2-Cut tube to length as per dwg D3887 (154.8") 3- Ensure squareness of Descriptions: ends and scribe batch#

130 - 1- Install drill Jig DT9477 drill X-bolt spacer pilot holes using 3/16" drill first side only. 2- 2nd side, locating from first saddle holes use DT9861 A/B to drill 2nd side fwd saddle holes. 3- 2nd side locating from fwd saddle drill remaining crossbolt spacer holes using DT9477 4- Open crossbolt spacer holes to finished size as per dwg D3887 (section D-D and E-E) ***DO NOT OPEN FWD Saddles Holes*** 5- Deburr, blow out chips from inside of tube. 6- Bond web in place as per Dwg D3887 & QSI 015. A/R Sikaflex-291 5163445 Sikaflex expire date: 4/23/19 Start: 19/03/24 Time: 2:30PM Finish: 19/03/24 Time: 2:30AM ***** (Adhere for 12 hours) *****

140 - 1- Bend FWD end of tube using bender 1 and bend prog. D3887. ***Must use bending aid DT9544, ensure proper positioning*** 2- Cut FWD end of tube as per dwg D3887. ***Verify measurement*** 3- Buff out marks left from bending 4- Drill FWD cap holes using DT8215. Open FWD & AFT cap holes to 0.208" 5- Open FWD saddle holes to finished size as per dwg D3887 6- Drill FWD x-bolt spacer holes using DT9816 and open to finished size. (verify measurement) 7- Drill Tow ring hole, using DT10047 locate from FWD saddle hole. (verify measurement). Open to finished size. 8- Drill 1.87" and 3.74 holes using DT10045 A&B locate from FWD saddle hole. (verify measurement) as per dwg. 9- C'sink FWD cap hole as per detail "C" 10- Countersink crossbolt spacer holes, and prepare tube for welding, deburr. 11- Deburr and blow out chips from inside of tube.

160 - NOTE: TACK IN 2 MOST FWD X-BOLT SPACERS AND TEST FIT FWD GROUND HANDLING FIXTURE, IF FIXTURE FITS WELL THEN PROCEED. FIXTURE DT10091. 1- Insert crossbolt spacers. Weld as per QSI 004 and Dwg D3887. Remember to back drill each hole before welding the other side. Use aluminum rod A/R Aluminum Rod 138989

2- Grind cross bolt welds flush as per Dwg D3887. Ensure no pin hole. 3- Counterbore x-bolt spacer holes as per Dwg D3887 using DT10279. 4- Deburr and blow out chips from inside of tube 5- Pick D2855-5 cap and transfer drill missing hole. Deburr and identify cap with skid tube batch#.

170 - TEST FIT USING FIXTURE DT10091.

200 - ***MASK AREA SHOWN ON SHEET 7, NOTE 9*** START TIME: 3:15 OVEN TEMPERATURE: 320° FINISH TIME: 3:45

240 - 1- Install wearplates as per Dwg D3887. 2- Inspect for foreign objects as per QSI 024 3- Install D2855-3 Cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 5163445 Sikaflex expire date: 19-4-22 4- Install insert in D2855- Cap. Install cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 5163445 Sikaflex expire date: 19-4-23

5- INSPECT TORQUE ON BOLTS AS PER DWG.

BY: _____ DATE: _____ 6- Wing Walk as per dwg QSI005 4.4 Batch: 5163430

258 - Photocopy bluefile & type labels per PPP D119-646-241 CHG005

260 - Location : FG108

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2500-1-190	Ext'n -1' Beam Tube 4"	1 pcs (1 ea)	90-Start up Operation	5112963
D2579	Crossbolt Spacer	2 pcs (2 ea)	140-Skidtubes	5097840
D3885-1	Standard Web	1 pcs (1 ea)	140-Skidtubes	5141106
D3681-1	Spacer	12 pcs (12 ea)	160-Skidtubes	5145873
D3903-1	Spacer	12 pcs (12 ea)	160-Skidtubes	5144956
ALS4-1032-225	Rivnut	1 Ea (1 ea)	240-HandFinish	5059809
AN3C46A	Bolt	8 Ea (8 ea)	240-HandFinish	5095398
AN3C5A	Bolt	2 Ea (2 ea)	240-HandFinish	5149186
D2855-3	Cap	1 pcs (1 ea)	240-HandFinish	5002078
D2855-5	Cap	1 pcs (1 ea)	240-HandFinish	5126403
D3492-045	Plug Assembly	8 pcs (8 ea)	240-HandFinish	5040473
D3672-1	Washer, Phenolic	2 pcs (2 ea)	240-HandFinish	5164008
D3849-041	Fwd Heavy-Duty Wearplate, Std Skid Compatible	1 pcs (1 ea)	240-HandFinish	5169287
D3849-043	Aft Heavy-Duty Wearplate, Std Skid Compatible	1 pcs (1 ea)	240-HandFinish	5116656
D3904-1	Washer	16 pcs (16 ea)	240-HandFinish	5141327
MS21043-3	Nut	8 Ea (8 ea)	240-HandFinish	5099569
MS24694-C52	Screw	2 Ea (2 ea)	240-HandFinish	5067269
NAS1149C0332R	Washer	2 Ea (2 ea)	240-HandFinish	5148669
				009277

Job Allocations

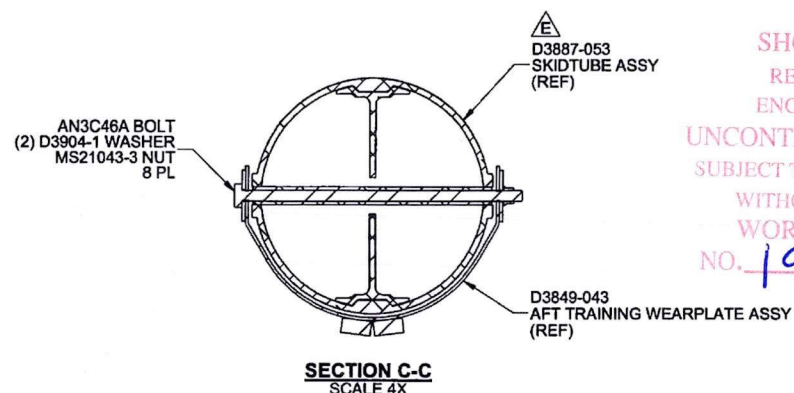
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2500-1-190	1	32	0
140-Skidtubes	D2579	2	118	0
	D3885-1	1	7	0
160-Skidtubes	D3681-1	12	204	0
	D3903-1	12	151	0
240-HandFinish	ALS4-1032-225	1	937	0
	AN3C46A	8	201	0
	AN3C5A	2	1,437	0
	D2855-3	1	32	0
	D2855-5	1	52	0
	D3492-045	8	36	0
	D3672-1	2	1,881	0
	D3849-041	1	1	0
	D3849-043	1	7	0
	D3904-1	16	64	0
	MS21043-3	8	941	0
	MS24694-C52	2	82	0
	NAS1149C0332R	2	5,033	0

Part Specifications

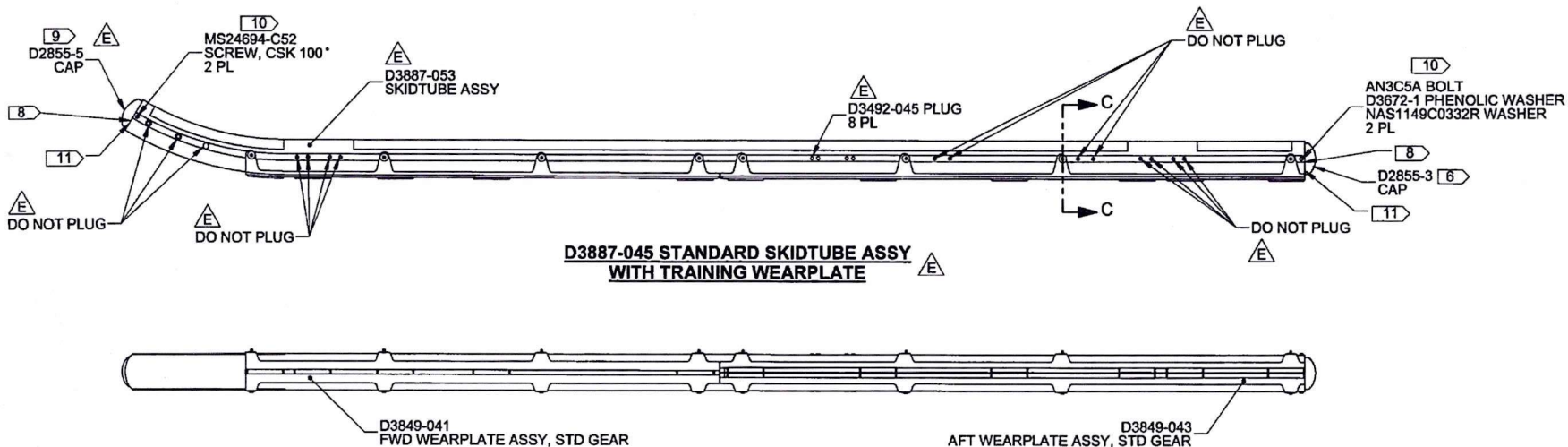
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Plex 3/21/19 10:07 AM Dart.lajeunesse.marie

ITEM	QTY -045	P/N	DESCRIPTION
	X	D3887-045	STANDARD SKIDTUBE ASSY WITH TRAINING WEARPLATE
1	1	D2855-3	CAP ASSY
2	1	D2855-5	CAP ASSY
3	8	D3492-045	PLUG
4	2	D3672-1	PHENOLIC WASHER
5	1	D3849-041	FWD WEARPLATE ASSY, STD GEAR
6	1	D3849-043	AFT WEARPLATE ASSY, STD GEAR
7	1	D3887-053	SKIDTUBE ASSY
8	16	D3904-1	WASHER
9	1	ALS4-1032-225	INSERT
10	8	AN3C46A	BOLT
11	2	AN3C5A	BOLT
12	8	MS21043-3	NUT, SELF-LOCKING
13	2	MS24694-C52	SCREW, CSK 100*
14	2	NAS1149C0332R	WASHER



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 192325
MW
1903-21



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3887-045" AND BATCH NUMBER PER QSI 044 6.4 ON THE ID OF THE TUBE, BEFORE INSTALLING THE AFT D2855-3 CAP
- 7) WEIGHT: 38.1 lbs
- 8) RELIEVE INNER RIDGE OF EXTRUSION, AS NEEDED, TO ALLOW FOR INSTALLATION OF D2855-3 AND D2855-5 CAP ASSY, ALODINE BARE MATERIAL
- 9) USE D3887-053 SKIDTUBE ASSY TO LOCATE AND BACKDRILL UNDRILLED INSERT HOLE INTO D2855-5 CAP. OPEN HOLE TO Ø0.297, ALODINE BARE MATERIAL AND INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP.
- 10) SEAL FASTENERS WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) SEAL MATING SURFACES WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

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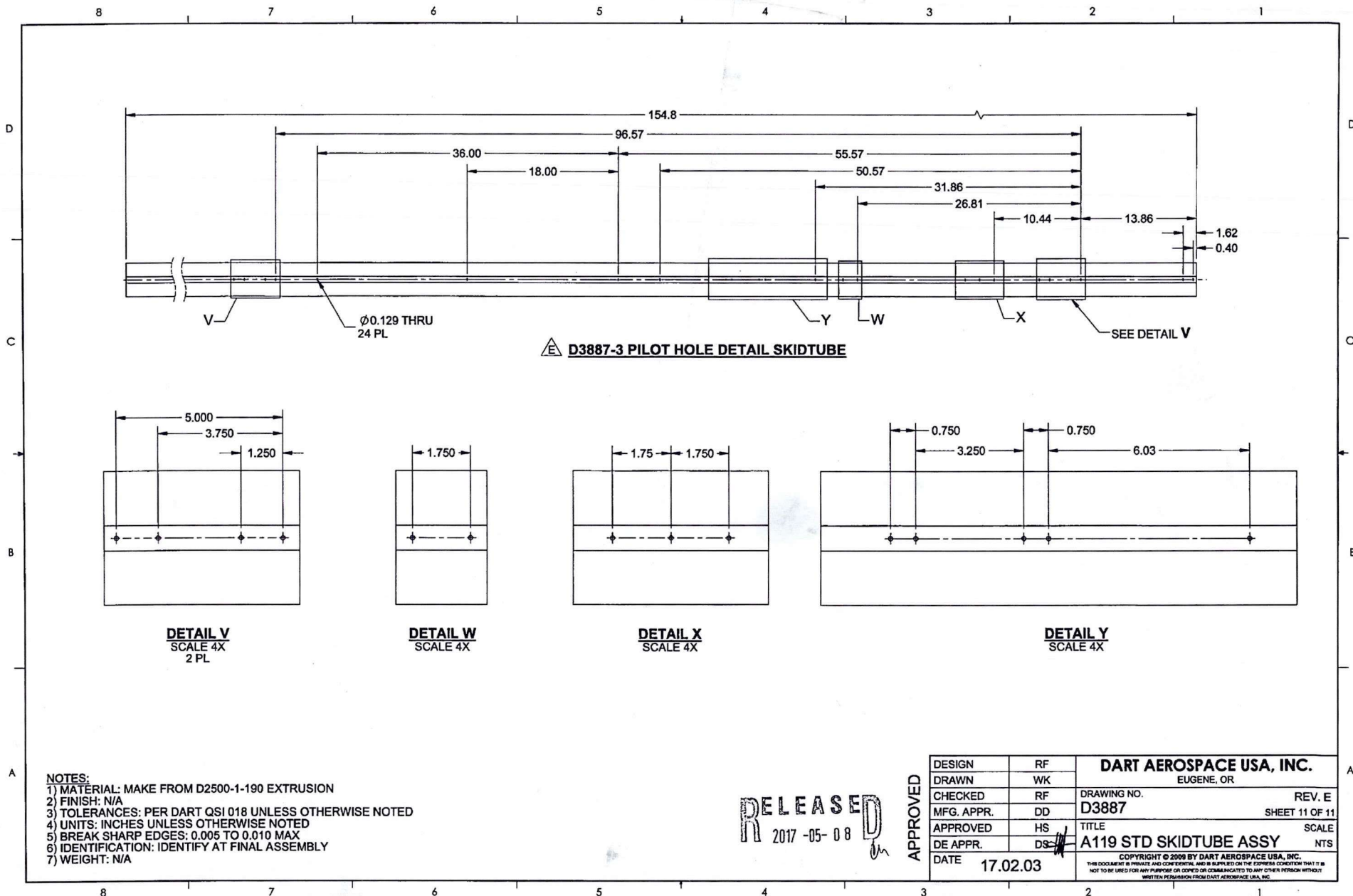
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CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	DD	D3887	SHEET 4 OF 11
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	A119 STD SKIDTUBE ASSY	NTS
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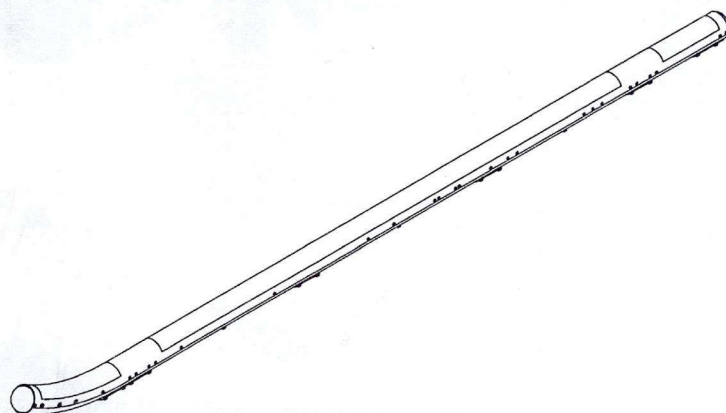
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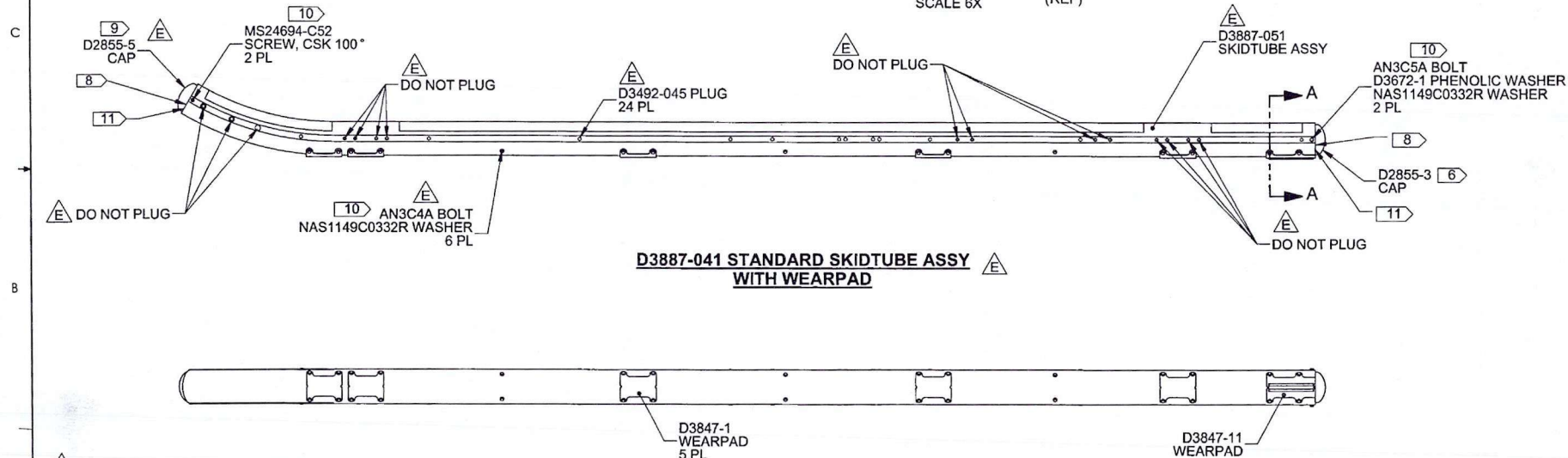
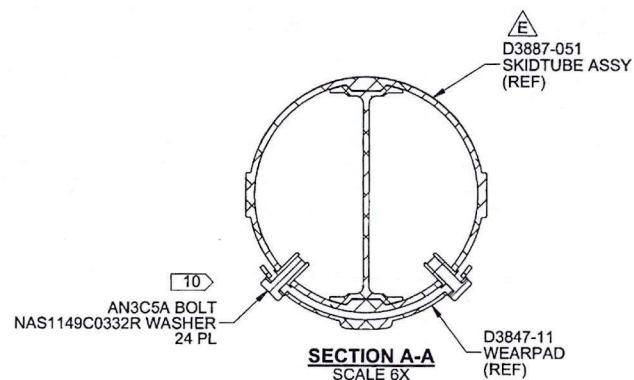
D3887-041 STANDARD SKIDTUBE ASSY WITH WEARPAD(SHOWN)
D3887-043 STANDARD SKIDTUBE ASSY WITH WEARPLATE (SIMILAR)
D3887-045 STANDARD SKIDTUBE ASSY WITH TRAINING WEARPLATE (SIMILAR)

E	COMPLETE REDRAW, ADDED ASSY DETAILS -3, -051 & -053, SEE PREVIOUS REV. FOR DETAIL. POWDER COAT REMOVED FROM SADDLE AREA SEE DETAIL F. REF PAR15-421. ADDED STRUCTURAL PROVISIONS TO ALLOW FOR THE INSTALLATION OF THE D119-646-313/314 SKIDTUBE PROTECTOR KIT. REF PAR17-577. CHANGE QTY OF D2855-3, ADDED D2855-5 CAP ASSEMBLIES, ADDED INSTRUCTIONS TO LOCATE INSERT HOLE FOR D2855-5 CAP. REF PAR17-583	AJS / WK	17.02.03
D	REVISED BEND TOLERANCES FOR MANUFACTURABILITY, 135.07 WAS 134.04 (ZN D5-8), ADD 5.07 (ZN C2-8), ADD 116.8 (ZN D5-8), DELETE GASKETS (BOM, SH 2)	DB	13.09.20
C	(SHT1, P/L, ZN C2-2, C3-2, C4-2) ITEM 13, QTY 2 WAS 4, ITEM 42, QTY 32 WAS 34, ITEM 44, QTY 30 WAS 32, ADD ITEM 46, MS24694-C52 WAS AN3C5A, 2 PLCS, (ZN C1-5, C1-6, B4-7) Ø0.201 CSK Ø0.385 X 100" WAS Ø0.214 THRU, ADDED DETAIL F (ZN C8-5, C8-6, B8-7), ADD ITEM 10, D2579 CROSS BOLT SPACER (ZN D4-1, A6-7)	DB	13.02.19
B	ALS4-1032-130 WAS AELS-1032-130 (ZN C4-1, C5-7, C3-7); ADD D18931 (ZN A8-1); ADD 134.04 (ZN C4-8); D2855-3 WAS D2575 (ZN D4-1, C7-2, C2-2, C7-3, C2-3, C7-4, C2-4); AN3C5A WAS AN3C4A (ZN C6-2, C2-2, C6-3, C2-3, C6-4, C2-4); Ø0.313 WAS Ø0.328 (ZN C4-5, C4-5, C2-7 & B3-7) REVISED NOTE iv (ZN B3-7)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	WK	EUGENE, OR	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	DD	D3887	SHEET 1 OF 11
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DE APPR.	DS	A119 STD SKIDTUBE ASSY	NTS
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3887-041	STANDARD SKIDTUBE ASSY WITH WEARPAD
1	1	D2855-3	CAP ASSY
2	1	D2855-5	CAP ASSY
3	24	D3492-045	PLUG ASSY
4	2	D3672-1	PHENOLIC WASHER
5	5	D3847-1	WEARPAD
6	1	D3847-11	WEARPAD
7	1	D3887-051	SKIDTUBE ASSY
8	1	ALS4-1032-225	INSERT
9	26	AN3C5A	BOLT
10	6	AN3C4A	BOLT
11	2	MS24694-C52	SCREW, CSK 100*
12	32	NAS1149C0332R	WASHER



**D3887-041 STANDARD SKIDTUBE ASSY
WITH WEARPAD**



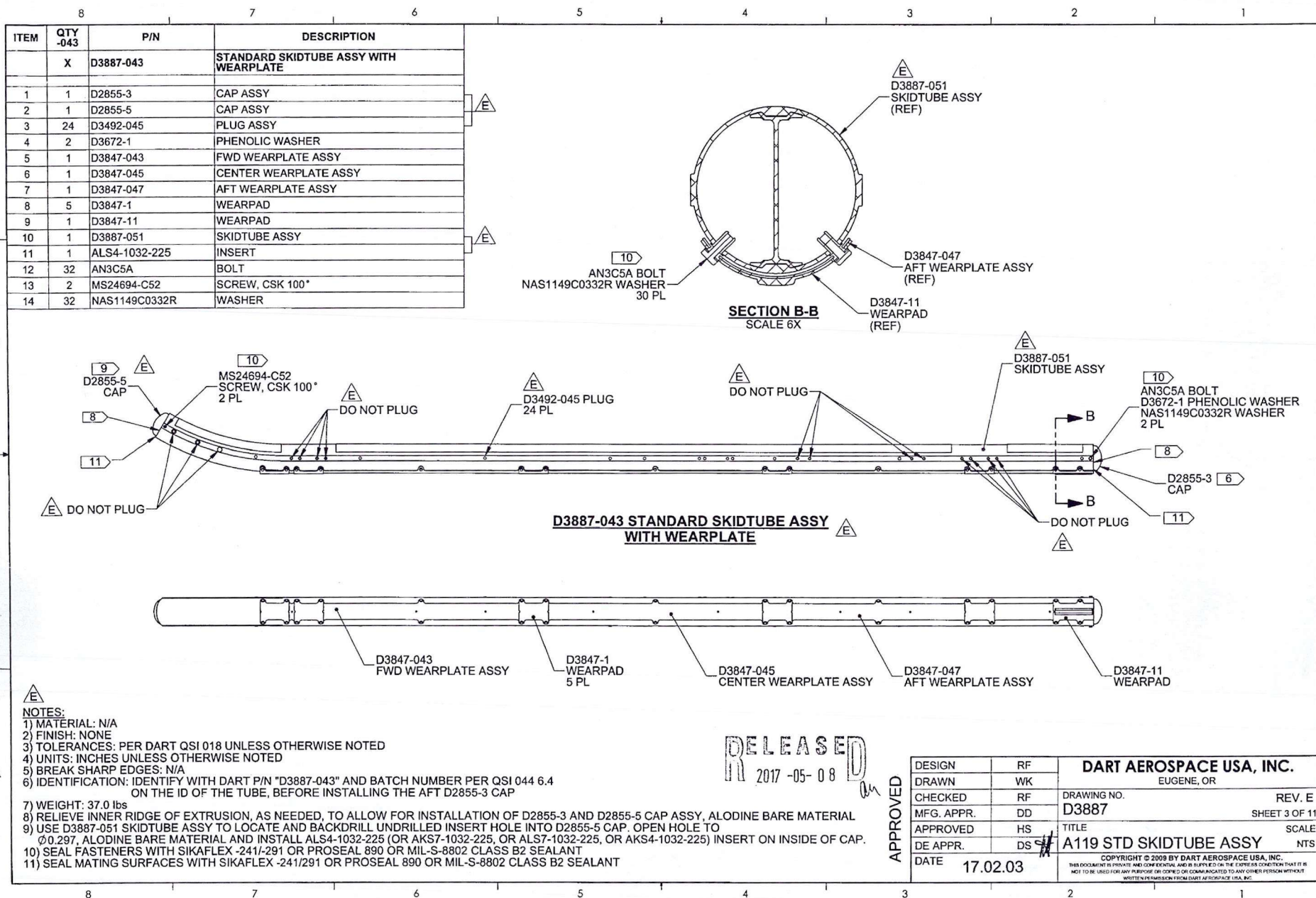
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3887-041" AND BATCH NUMBER PER QSI 044 6.4 ON THE ID OF THE TUBE, BEFORE INSTALLING THE AFT D2855-3 CAP
- 7) WEIGHT: 32.0 lbs
- 8) RELIEVE INNER RIDGE OF EXTRUSION, AS NEEDED, TO ALLOW FOR INSTALLATION OF D2855-3 AND D2855-5 CAP ASSY, ALODINE BARE MATERIAL
- 9) USE D3887-051 SKIDTUBE ASSY TO LOCATE AND BACKDRILL UNDRILLED INSERT HOLE INTO D2855-5 CAP. OPEN HOLE TO Ø0.297, ALODINE BARE MATERIAL AND INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP.
- 10) SEAL FASTENERS WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) SEAL MATING SURFACES WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

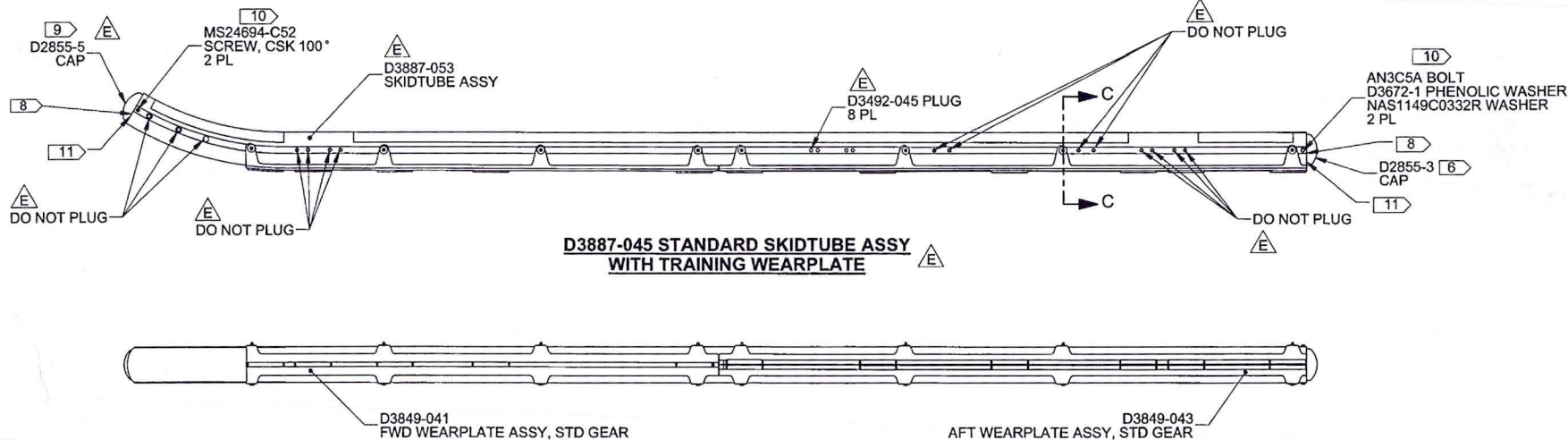
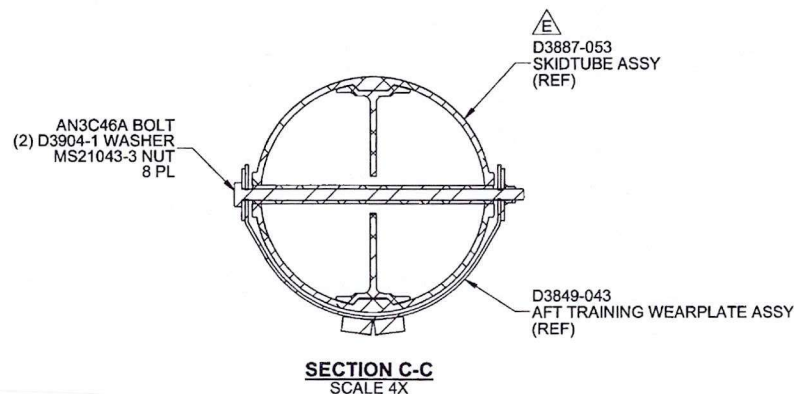
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ITEM	QTY -045	P/N	DESCRIPTION
	X	D3887-045	STANDARD SKIDTUBE ASSY WITH TRAINING WEARPLATE
1	1	D2855-3	CAP ASSY
2	1	D2855-5	CAP ASSY
3	8	D3492-045	PLUG
4	2	D3672-1	PHENOLIC WASHER
5	1	D3849-041	FWD WEARPLATE ASSY, STD GEAR
6	1	D3849-043	AFT WEARPLATE ASSY, STD GEAR
7	1	D3887-053	SKIDTUBE ASSY
8	16	D3904-1	WASHER
9	1	ALS4-1032-225	INSERT
10	8	AN3C46A	BOLT
11	2	AN3C5A	BOLT
12	8	MS21043-3	NUT, SELF-LOCKING
13	2	MS24694-C52	SCREW, CSK 100"
14	2	NAS1149C0332R	WASHER



NOTES:

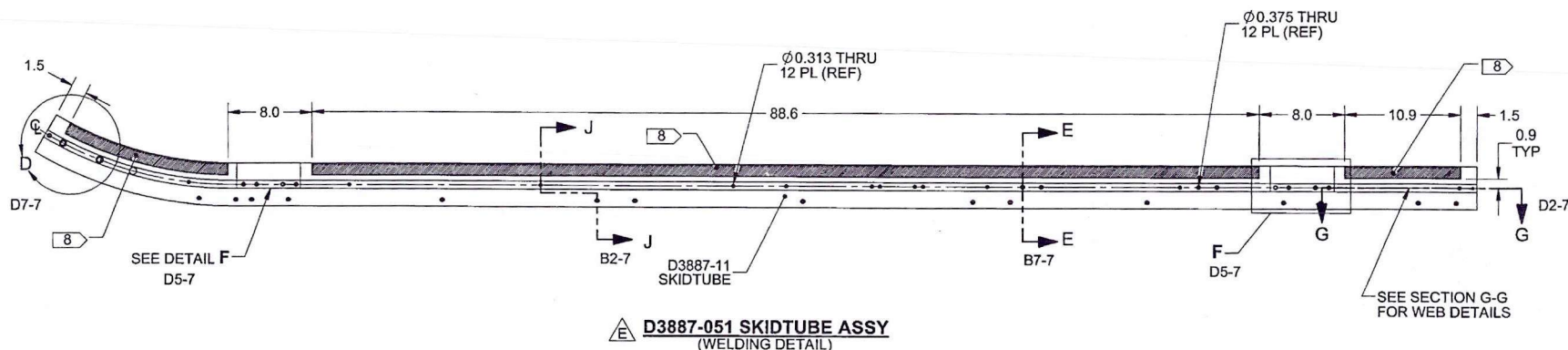
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3887-045" AND BATCH NUMBER PER QSI 044 6.4 ON THE ID OF THE TUBE, BEFORE INSTALLING THE AFT D2855-3 CAP
- 7) WEIGHT: 38.1 lbs
- 8) RELIEVE INNER RIDGE OF EXTRUSION, AS NEEDED, TO ALLOW FOR INSTALLATION OF D2855-3 AND D2855-5 CAP ASSY, ALODINE BARE MATERIAL
- 9) USE D3887-053 SKIDTUBE ASSY TO LOCATE AND BACKDRILL UNDRILLED INSERT HOLE INTO D2855-5 CAP. OPEN HOLE TO $\phi 0.297$, ALODINE BARE MATERIAL AND INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP.
- 10) SEAL FASTENERS WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) SEAL MATING SURFACES WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

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DE APPR.	DS	A119 STD SKIDTUBE ASSY	NTS
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ITEM	QTY -051	P/N	DESCRIPTION
	X	D3887-051	SKIDTUBE ASSY
1	2	D2579	CROSS BOLT SPACER
2	12	D3681-1	CROSS BOLT SPACER
3	1	D3885-1	STANDARD WEB
4	1	D3887-11	SKIDTUBE
5	12	D3903-1	CROSS BOLT SPACER
6	30	ALS4-1032-130	INSERT



D3887-051 SKIDTUBE ASSY
(WELDING DETAIL)

NOTES:

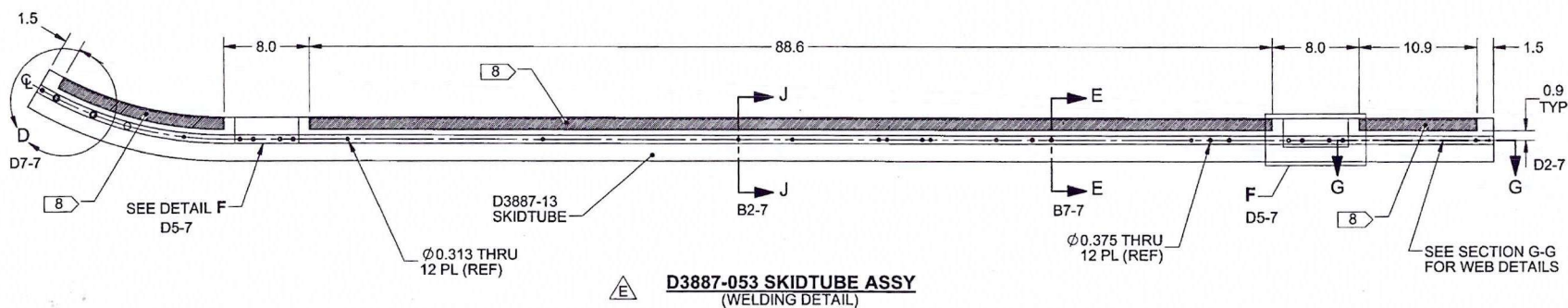
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
- 7) WEIGHT: N/A
- 8) AFTER APPLICATION OF FINISH, PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 0.50 ABOVE LOCATION RIDGE, PER QSI 005 SECTION 4.4

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MFG. APPR.	DD	D3887	SHEET 5 OF 11
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	A119 STD SKIDTUBE ASSY	NTS
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ITEM	QTY -053	P/N	DESCRIPTION
	X	D3887-053	SKIDTUBE ASSY
1	2	D2579	CROSS BOLT SPACER
2	12	D3681-1	CROSS BOLT SPACER
3	1	D3885-1	STANDARD WEB
4	1	D3887-13	SKIDTUBE
5	12	D3903-1	CROSS BOLT SPACER



D3887-053 SKIDTUBE ASSY
(WELDING DETAIL)

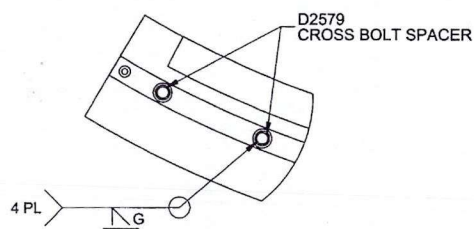
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
- 7) WEIGHT: N/A
- 8) AFTER APPLICATION OF FINISH, PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 0.50 ABOVE LOCATION RIDGE, PER QSI 005 SECTION 4.4

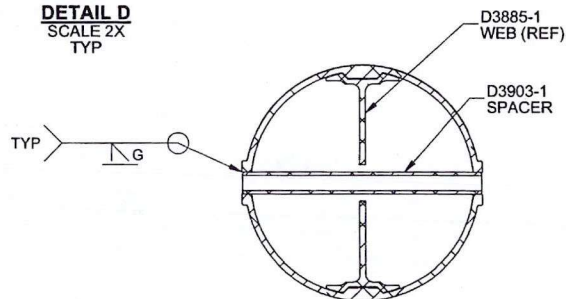
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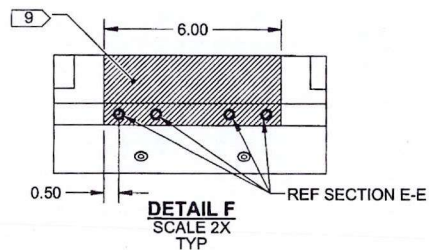


DETAIL D
SCALE 2X
TYP

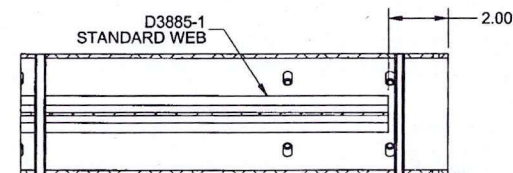


SECTION E-E
SCALE 5X
TYP

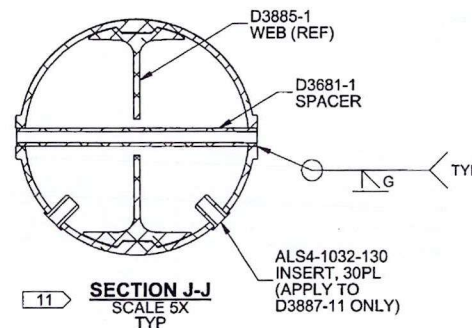
(FOR 12X $\phi 0.375$ HOLES
PER SKIDTUBE)



DETAIL F
SCALE 2X
TYP



SECTION G-G
SCALE 2X
TYP



SECTION J-J
SCALE 5X
TYP

(FOR 12X $\phi 0.313$ HOLES
PER SKIDTUBE)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) INSERT D3885-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING. ENSURE HOLES LINE-UP
- 9) MASK THIS AREA AND DO NOT POWDER COAT
- 10) AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR THE SECTION E-E $\phi 0.375$ HOLES ONLY:
 - i) CHAMFER HOLES $\phi 0.475 \times 45^\circ$
 - ii) INSERT D3903-1 SPACER
 - iii) WELD INTO PLACE AND GRIND FLUSH
 - iv) C'BORE TO $\phi 0.313 \times 0.75$ DEEP
 - v) DEBURR HOLES
- 11) AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR THE SECTION J-J $\phi 0.313$ HOLES ONLY:
 - i) CHAMFER HOLES $\phi 0.354 \times 45^\circ$ OR 0.050 DEEP $\times 45^\circ$ (BOTH SIDES)
 - ii) INSERT D3681-1 SPACER
 - iii) WELD INTO PLACE AND GRIND FLUSH
 - iv) DEBURR HOLES
- 12) WELD PER DART QSI 004

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D3887-11 DRILLING DETAIL SKIDTUBE

WEARPAD/WEARPLATE HOLE PATTERN
FOR REFERENCE ONLY
DRILL USING DT8931 TEMPLATE

DETAIL M
SCALE 2X

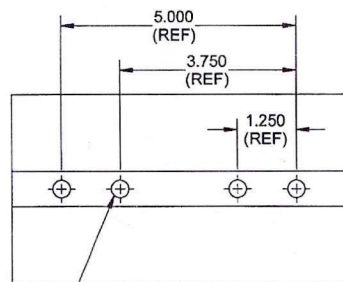
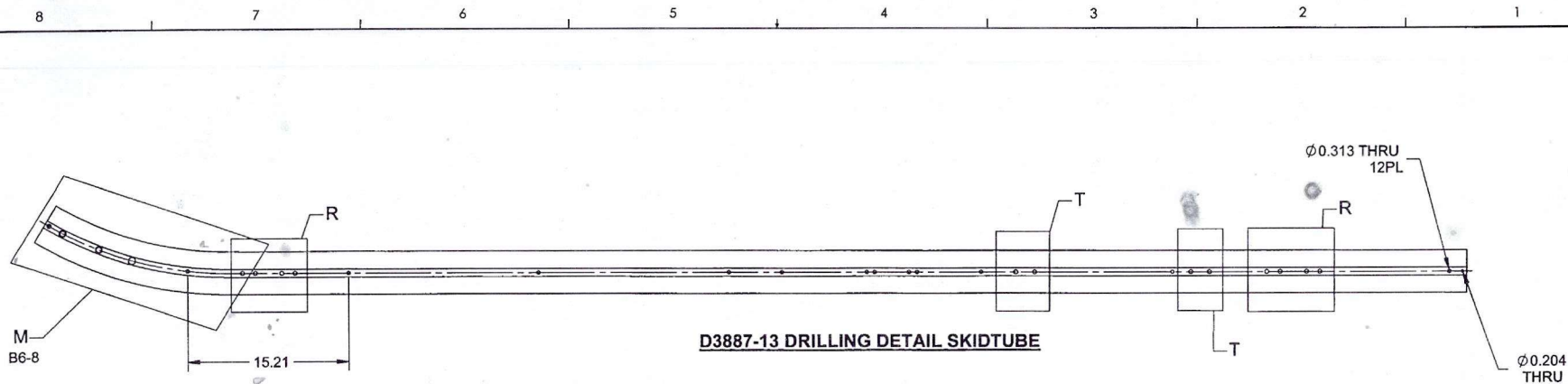
SECTION N-N
SCALE 4X
15 PL

- NOTES:**
- 1) MATERIAL: MAKE -11 FROM -1 BEND DETAIL
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
 - 7) WEIGHT: N/A
 - 8) USE DART DRILL TEMPLATE DT8931 TO LOCATE AND DRILL $\phi 0.297$ HOLES FOR WEARPAD/WEARPLATE INSERTS.

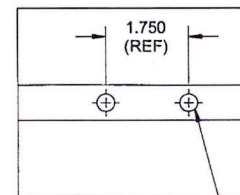
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DETAIL R
SCALE 4x
2PL



DETAIL T
SCALE 4x
2PL

NOTES:

- 1) MATERIAL: MAKE -13 FROM -1 BEND DETAIL
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A

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8 7 6 5 4 3 2 1

D

D

C

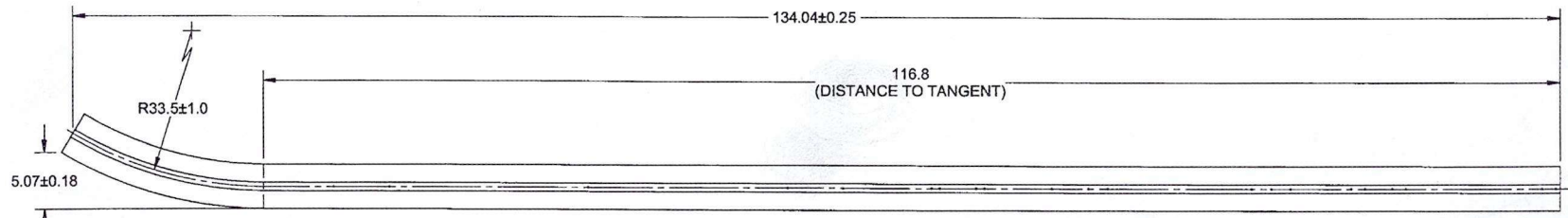
C

B

B

A

A



D3887-1 BEND DETAIL SKIDTUBE

NOTES:

- 1) MATERIAL: MAKE -1 BEND DETAIL FROM -3 PILOT HOLE DETAIL
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8.5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

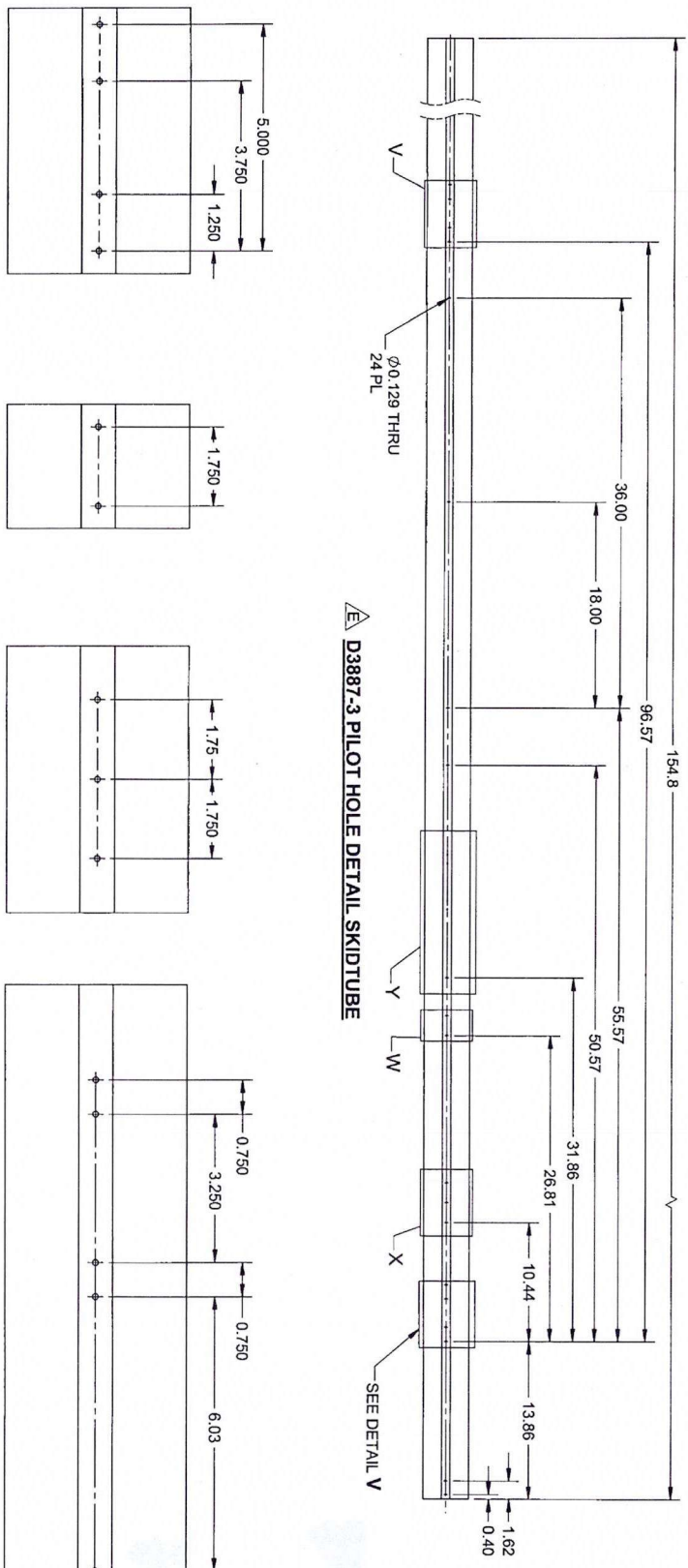
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8 7 6 5 4 3 2 1

D3887-3 PILOT HOLE DETAIL SKIDTUBE



DETAIL V
SCALE 4X
2 PL

DETAIL W
SCALE 4X

DETAIL X
SCALE 4X

DETAIL Y
SCALE 4X

- NOTES:**
- 1) MATERIAL: MAKE FROM D2500-1-190 EXTRUSION
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
 - 7) WEIGHT: N/A

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DATE	17.02.03		
TITLE	A119 STD SKIDTUBE ASSY		
COMPONENT	A119 STD SKIDTUBE ASSY		
SCALE	NTS		

Change Record

PAGE 1 OF 1

Part Number: D119-646-241

Description: REPLACEMENT STD SKIDTUBE w/ TRAINING WEARPLATES

[illegible]